

Date: Monday, 11/6/2006 1:44:06 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	WINDOW ASSEMBLY
<b>Job Number</b> :	29308B		
<b>Estimate Number</b> :	10304		
<b>P.O. Number</b> :		<b>Part Number</b> :	D3136043
<b>This Issue</b> :	11/6/2006	<b>Drawing Number</b> :	D3136 REV D
<b>Prsht Rev.</b> :	NC	<b>Project Number</b> :	N/A
<b>First Issue</b> :	11	<b>Drawing Revision</b> :	D
<b>Previous Run</b> :	29148B	<b>Material</b> :	
<b>Written By</b> :		<b>Due Date</b> :	11/30/2006
<b>Checked &amp; Approved By</b> :	<i>[Signature]</i>	<b>Qty:</b>	<i>20</i> Um: Each
<b>Comment</b> :	Est Rev: A 04.02.04 New issue KJ/DS		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: *2435*

Order D3136-3 per Dwg D3136

Supplier: -Canus

Fabricate as per Dwg D3136

Apply 3M Protective Masking Film on top side only as per Dwg D3136

Material release note required

*C Loc 111107 (20)*

2.0

D31363

WINDOW



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
 WINDOW

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure material certification is attached

*Cancel  
hermes in house*

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5.0

D31089

Decal



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part# Description Batch

2 D3108-9 Decal

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/6/2006 1:44:07 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WINDOW ASSEMBLY

Job Number: 29308B

Part Number: D3136043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Trim back masking film as per Dwg D3136 and apply D3108-9 decals to inside surface of windows.

2-Engrave Part number and Batch number as per Dwg D3136

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

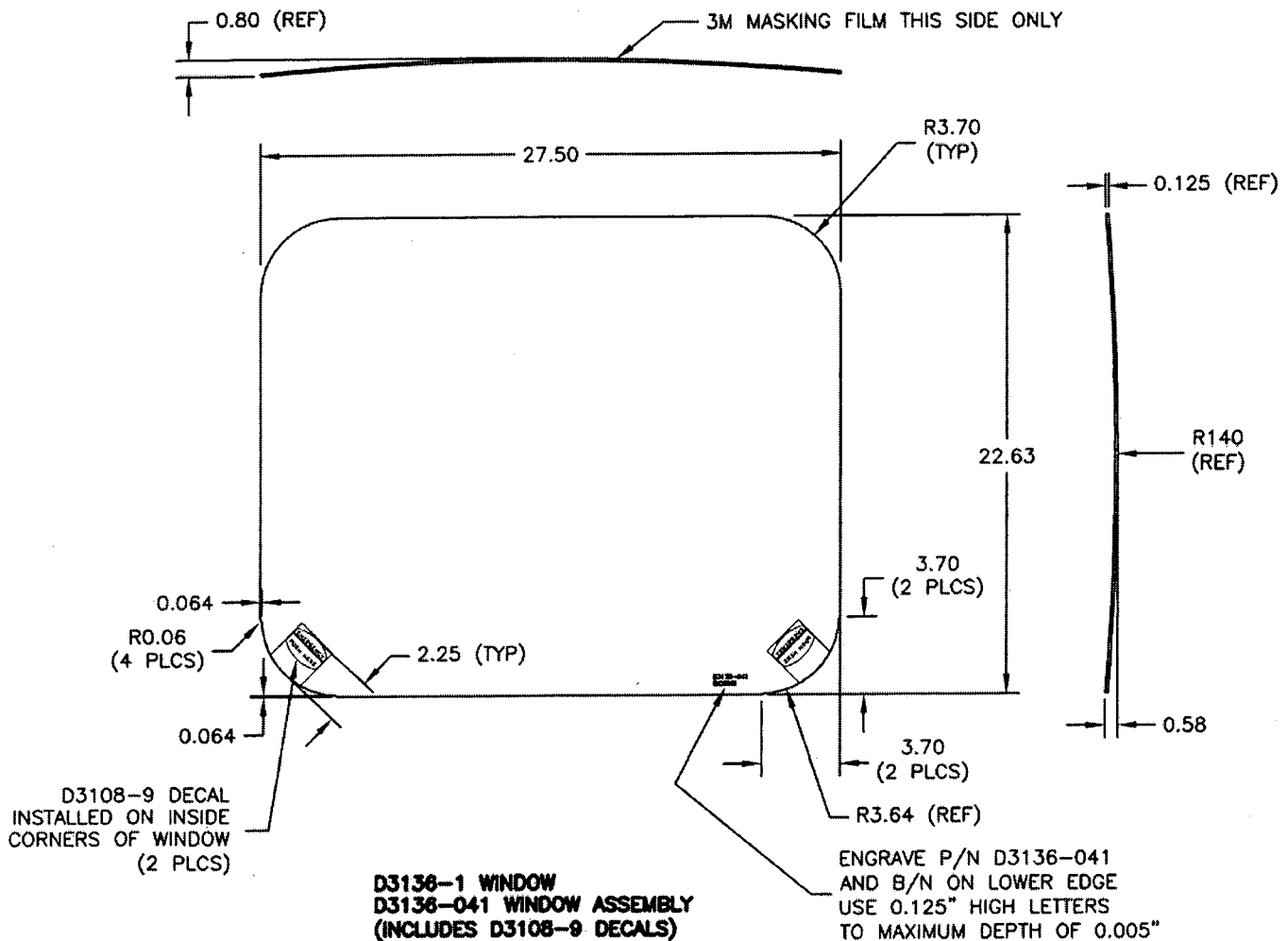
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART****RELEASED**  
05.12.01

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3136	REV. D SHEET 1 OF 2
DATE 05.12.01		TITLE WINDOW ASSEMBLY	SCALE 1:8
A	02.04.18	NEW ISSUE	
B	04.01.21	ADDED D3136-3 AND D3136-043	
C	04.05.05	ADDED FORMING & ENGRAVING SPEC	
D	05.12.01	UPDATED MATERIAL NOTES	

**NOTES:**

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET FER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK
- 2) FORMING PROCESS: a) HEAT LARGER PIECE TO 250° F  
b) DRAPE OVER D3136-T1 MOLD & CLAMP  
c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS  
d) TRIM PER TEMPLATE D3136-1T2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

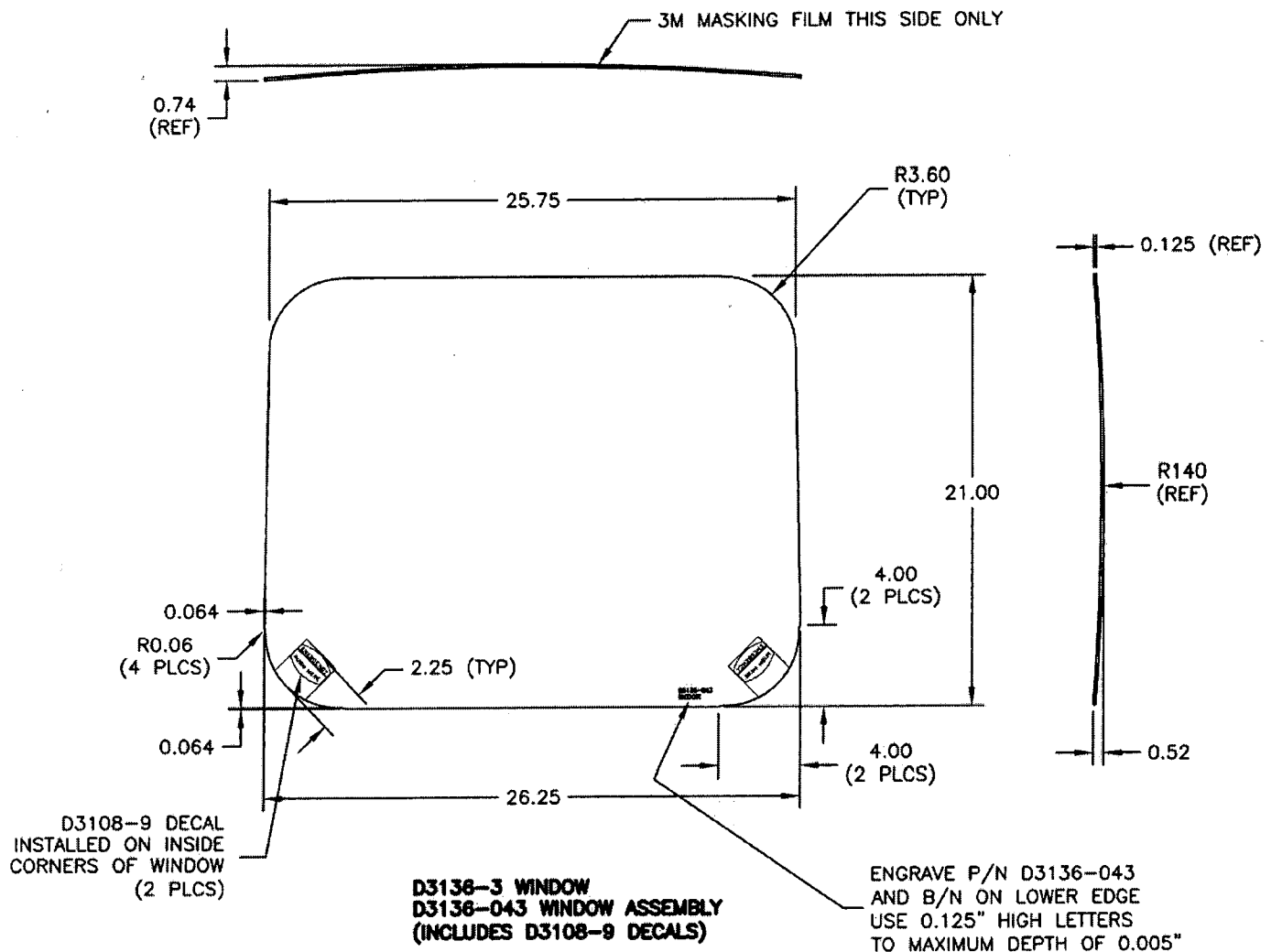
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**DART**

DESIGN [Signature]	DRAWN BY [Signature]	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3136	REV. D SHEET 2 OF 2
DATE 05.12.01		TITLE WINDOW ASSEMBLY	SCALE 1:8

**RELEASED**  
05.12.01 [Signature]**NOTES:**

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK
- 2) FORMING PROCESS: a) HEAT LARGER PIECE TO 250° F  
b) DRAPE OVER D3136-T1 MOLD & CLAMP  
c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS  
d) TRIM PER TEMPLATE D3136-3T1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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